

Work Order ID 146749

Tuesday, May 24, 2016 9:50:48 AM

146749

Page 1

Item ID: D500-572-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: MD369/MD500 Bearpaws

Start Date: 5/11/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								
IIND500-572	RevA								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D500-572-011								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									

DAS
6
9-89

AUG 03 2016

2X

DAS
28
9-89

AUG 08 2016

2 PC

DAS
27
9-89

AUG 04 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 146749

Tuesday, May 24, 2016 9:50:48 AM

146749

Page 2

Item ID: D500-572-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: MD369/MD500 Bearpaws

Start Date: 5/11/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

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Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.00							
170						2x	DAS	AUG 08 2016	
QC	Memo	0.06					28		
Quality Control							9-89		
180		0.00							
180	Packaging					2x	DAS	AUG 08 2016	
Packaging	Memo	0.00					28		
Packaging	Identify and pack for shipping as per PPPD500-572-011						9-89		
	LOCATION: FG013								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.20							
Quality Control									

[Signature] 16.08.09

[Signature] AUG 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Page 1

Work Order ID: 146749

146749

Parent Item: D500-572-011

D500-572-011

Parent Item Name: MD369/MD500 Bearpaws

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changedKJ/JLM
 IPP Rev:D 07-01-02 Was K10007 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A		Purchased		No		170	Each	438.0000	8	16			
AN4-15A													
Bolt													

Location	Loc Qty	Loc Code
GA	26	
120449	26	
OVER002	150	
m134762	150	
over003	200	
m134676	200	
ST343	62	
m134606	62	

D2182B		Manufactured	No			170	f	435.3793	1.666	3.332			
D2182B													

Rubber Cushion - Black (\$Per Foot)

Location	Loc Qty	Loc Code
ST411	435.3793	
130427	85.3793	
135093	350	

DAS
28
9-89

AUG 04 2016

DQA: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
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Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
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Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

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Page 2

Work Order ID: 146749

146749

Parent Item: D500-572-011

D500-572-011

Parent Item Name: MD369/MD500 Bearpaws

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

D2274

Manufactured No

170

Each

390.0000

8

16

D2274

Radius Block

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

378

144391

378

**

4x B110264 PC
12x B146629 PC
DAS 27 9-89

D2435

Manufactured No

170

Each

0.0000

2

4

D2435

Bearpaw

DAS
28
9-89

**

145919

DAS 27 9-89

D2438

Manufactured No

170

Each

76.0000

4

8

D2438

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST542

76

131052

16

140182

60

**

x2 B110276 PC
DAS 27 9-89

D2529

Manufactured No

170

Each

523.0000

8

16

D2529

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008

523

143819

273

145269

250

**

PC
DAS 27 9-89

AUG 04 2016

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Shop Packet Print

Page 2

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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Parent Item Name: MD369/MD500 Bearpaws

146749

D500-572-011

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

170

Each

2,027.000

8

MS21042L4

Locknut

**

16
X M135127 PC
DAS
27
9-89

Location

Loc Qty

Loc Code

GA

187

m133769

187

OVER007

1500

m134676

500

m134762

1000

ST303

243

m134606

243

ST305

97

m130922

97

DAS
28
9-89

NAS1149D0463J

Purchased

No

170

Each

3,247.000

8

NAS1149D0463J

WASHER

**

16
X M134943 PC
DAS
27
9-89

Location

Loc Qty

Loc Code

GA

146

M132035

21

M134508

125

ST260a

2600

M134754

2600

ST263

501

M134634

501

DAS
28
9-89

QS200-M44S

Purchased

No

120

Each

30.0000

2

QS200-M44S

CLAMP

**

PC
DAS
27
9-89

Location

Loc Qty

Loc Code

ST545

30

m131340

10

m133363

20

DAS
28
9-89

AUG 04 2016

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								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kG 0.0 m-kG	130 in 3.30 m	1105 in-lb 12.74 m-kG
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kG 0.0 m-kG	130 in 3.30 m	975 in-lb 11.25 m-kG
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kG 0.0 m-kG	128 in 3.25 m	1459 in-lb 16.80 m-kG
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kG 0.0 m-kG	122 in 3.10 m	1391 in-lb 16.03 m-kG

5. PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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Revision: A

Date: 01.02.21

Work Order ID 146749

146749

Page 1

Tuesday, May 24, 2016 9:50:48 AM

Item ID: D500-572-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: MD369/MD500 Bearpaws

Start Date: 5/11/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								
IIND500-572	RevA								

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D500-572-011 CHG005

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DAS
21
9-89

AUG 02 2016